

Work Order ID 80039

Thursday, February 09, 2012 10:15:03 AM

80039

Page 1

Item ID: D3999-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Angle

Stop ***NS2***

Start Date: 2/10/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 2/24/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: *MX*

Date: *12-02-09*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3999	A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *A*

Prog Rev: *A*

6061 . 040

2-Deburr if necessary

B12-2-9

(Signature)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-2-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

8/12/12/13

counted
27

SB 12/02/13

27

27 12-2-14

W/O:		WORK ORDER CHANGES					
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Accept

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Stop ***NS2***

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20

Cust Item ID:

Required Date: 2/24/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept Reject Reject Insp.
Qty Qty Number Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 6-A

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

cont
(27)

12/02/15 (27)

12/2/15

12/02/15 (27)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, February 09, 2012 10:15:02 AM

Page 1

Work Order ID: 80039

Parent Item: D3999-5

Parent Item Name: Angle

Start Date: 2/10/2012

Required Date: 2/24/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP rev A 09.12.16 new issue Prelim EC verified by:DD IPP rev B 10.05.10 ecn 10-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	312.3670	0.048	1.0105263			
6061-T6 .040 Sheet													

Location

Loc Qty

Loc Code

MAT021

312.367

113004

1.5

117653

40.91

120154

90

120218

179.957

113004

28

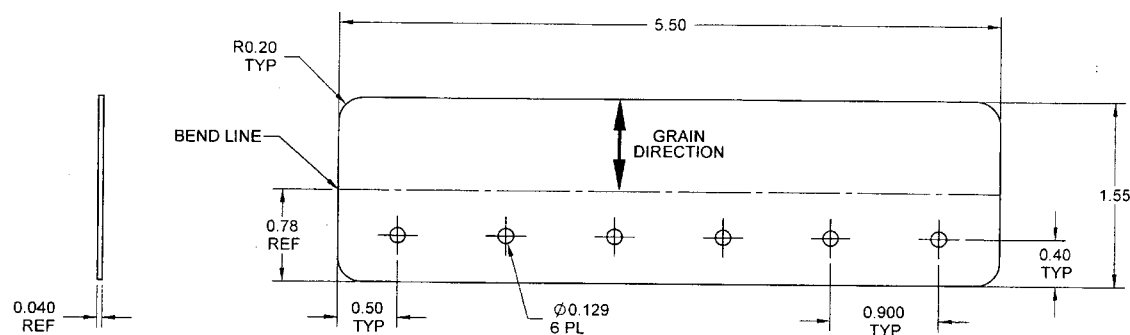
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D3999-5F FLAT PATTERN

RELEASED
2010-05-05
JNP

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.040
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.03 lbs

80039

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3999	REV. A
MFG. APPR.			SHEET 7 OF 12
APPROVED		TITLE BAFFLE	SCALE
DE APPR.			NTS
DATE	10.02.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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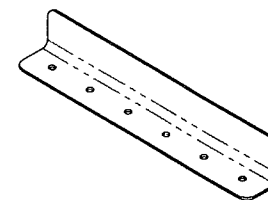
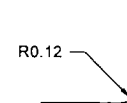
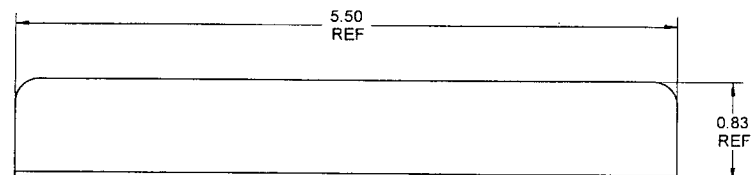
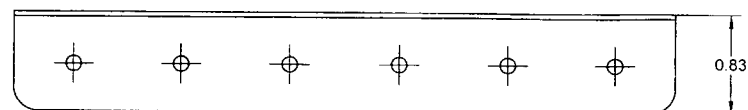
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-5	REF JCA-M47-1-02 REF JCA-M47-1-03



D3999-5 ANGLE

RELEASED
2010-05-05
MD

80039

- NOTES:**
- 1) MATERIAL: MADE FROM D3999-5F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3999	REV. A
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DATE	10.02.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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